Qty:

300 Um:

Each

: CROSSBOLT SPACER

: D2579

: N/A

; E

D2579 REV E

: 4/10/2008

Tuesday, 3/11/2008 7:57:40 AM

User:

Kim Johnston

Process Sheet

Drawing Name

Part Number

Material

Due Date

Drawing Number

Project Number

Drawing Revision

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

S.O. No. :

: 37752 Estimate Number

: 10993

P.O. Number This Issue

: 3/11/2008

: NC Prsht Rev.

Checked & Approved By

First Issue Previous Run

Written By

Comment

: 11

: 37275

Type

: MACHINED PARTS

: Est E

Now turned on Cobra NG

F 07.07.06 rev E dwg est

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

2.0

3.0

4.0

M6061T6T0500W058

6061-T6 Tube .500 x.058W

HARDINGE

Comment: Qty.:

0.3762 f(s)/Unit

Total: 112.8645 f(s)

6061-T6 Tube .500 x.058W

Material: 6061-T6 (WW-T-700/6) or 5052-H32 (WW-T-700/4)

0.500 Dia x 0.058 Wall

Batch M 107403

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

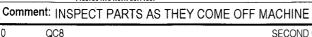
Machine as per Folio FA245

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



SECOND CHECK





Comment: SECOND CHECK

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location: 4

BE 08-04-03

| Dart Ae | rospace L | td | | | | | | | | |
|-------------|-----------|-------------------|----------------------|------------------------------|-----------|-------------|----------|-------|-------------------------------------|--|
| W/O: | | | W | ORK ORDER CH | ANGES | | | | | |
| DATE | STEP | STEP PRO | | EDURE CHANGE | | | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | | | |
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| | | | | | | | | | | |
| Part No | • | PAR #: | Fault Cat | egory: | NC | R: Yes | No DQ | A: | Date: | |
| | | | | | | QA: N | /C Close | d: | _ Date: _ | |
| NCR: | | , | WORK ORE | ER NON-CONFO | RMANCE | (NCR | 2) | | | A Company of the Comp |
| DATE | OTED | Description of NC | | Corrective Action | Section B | | Verific | ation | Approval | Approval |
| DATE | SIEP | STEP Section A | Initial Chief Eng | Action Description Chief Eng | | Sign & Date | Secti | | Chief Eng | QC Inspector |
| | | | | | | | | | | |
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NOTE: Date & initial all entries

Date:

Tuesday, 3/11/2008 7:57:40 AM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 37752

Part Number: D2579

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/08

Job Completion



W08.04

| Dart Ae | rospace | Ltd | | | | | | |
|---------|---------|------------------------------------|------------------------------|---------------------------|------------|--------------|---------------------------------------|--------------------------|
| W/O: | | | ٧ | VORK ORDER CHANGE | S | | · · · · · · · · · · · · · · · · · · · | |
| DATE | STEP | PROCEDURE CHANGE | | | Ву | Date Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |
| Part No | : | PAR #: | Fault Ca | tegory: | NCR: Yes 1 | lo DQA: | Date: | |
| | | | | | | C Closed: | | |
| NCR: | | W | ORK OR | DER NON-CONFORMAN | ICE (NCR) | | | |
| DATE | OTED | Description of NC | | Corrective Action Section | | Verification | Approval | Approval |
| DATE | STEP | Section A Initial Action Chief Eng | Action Description Chief Eng | Sign & Date | Section C | Chief Eng | QC Inspector | |
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NOTE: Date & initial all entries

| DART AEROSPACE LTD | Work Order: | 37752 |
|--------------------------------|--------------|-------------|
| Description: Cross Bolt Spacer | Part Number: | D2579 |
| Inspection Dwg: D2579 Rev: E | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

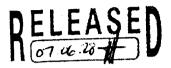
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|----------------------|---------------|------------------|--------|--------|-------------------------|----------|
| 4.070 | +/-0.030 | 4-065 | 1 | | | |
| 0.058 | +/-0.010 | 4.065 | ノ | | | |
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| | 100-100-100-1 | | | | | |

| Measured by: | JL | Audited by: RG | Prototype Approval: | N/A |
|--------------|----------|----------------|---------------------|-----|
| Date: | 03/04/02 | Date: 08/04/02 | Date: | N/A |

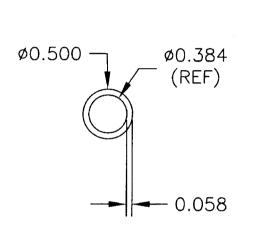
| Rev | Date | Change | Revised by Ap | proved |
|-----|----------|-----------------|---------------|--------|
| Α | 03.11.27 | New Issue | KJ/RF | |
| В | 07.09.06 | Dwg Rev updated | KJ/JLM X | B |
| | | | 70 | |

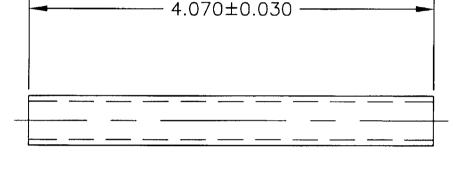


| DESIGN DRAWN BY | | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
|-----------------|--------|----------|---|---------------------------------------|--|
| CHEC | KED 11 | APPROVED | DRAWING NO. | REV. E | |
| | - | W W | D2579 | SHEET 1 OF 1 | |
| DATE | · | | TITLE | SCALE | |
| 07.0 | 04.17 | | CROSS BOLT SPACER | 1:1 | |
| Α | | 96.09.16 | NEW ISSUE | | |
| В | | 96.12.05 | 0.065 WALL WAS 0.035 WALL | | |
| С | | 97.02.21 | 0.058 WALL WAS 0.065 WALL | · · · · · · · · · · · · · · · · · · · | |



| 07.0 | J 4. 17 | CROSS BULL SPACER 1:1 |
|------|--------------------|------------------------------------|
| Α | 96.09.16 | NEW ISSUE |
| В | 96.12.05 | 0.065 WALL WAS 0.035 WALL |
| O | 97.02.21 | 0.058 WALL WAS 0.065 WALL |
| ۵ | 99.05.19 | 4.070 LENGTH WAS 4.100 (TSR A1095) |
| E | 07.04.17 | UPDATE NOTES |
| | A B C | B 96.12.05 C 97.02.21 D 99.05.19 |





D2579 CROSS BOLT SPACER

D2579 CROSS BOLT SPACER

MATERIAL:

6061-T6 TUBING PER WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8

(REF DART SPEC M6061T6T0500W058)

RETURN TO

2) FINISH:

3)

4)

NONE

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ENGINTERING INCONTROLLED COPY SCHUPET TO AMENDMENT

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